

Date: Wednesday, 11/23/2005 7:17:54 PM
User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DOUBLER |
| Job Number | : 24956D | | |
| Estimate Number | : 10296 | | |
| P.O. Number | : N/A | Part Number | : D32203 |
| This Issue | : 11/23/2005 S.O. No. : N/A | Drawing Number | : D3220 REV A1 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : MACHINED PARTS | Drawing Revision | : A1 |
| Previous Run | : 23722D | Material | : D/A |
| | | Due Date | : 12/20/2005 |
| Written By | : See Comment below | Qty: | 12 Um: Each |
| Checked & Approved By | : See Comment below | | |
| Comment | : Est Rev: A New Issue 05-11-06 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S050 | 2024-T3 .050 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.6233 sf(s)/Unit Total: 6.2328 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.050" thick
(M2024T3S.050
Identify for D3220-3
Batch: B19053

| | | |
|-----|----------|-----|
| sig | Date | Qty |
| SAD | 26/11/05 | 12 |

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: Cut D3220-3: 13.320" x 6.94" grain along 13.320"

| | | |
|-----|----------|----|
| SAD | 25/11/05 | 12 |
|-----|----------|----|

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind Corner Rads As per Dwg D3220

2-Deburr

| | | |
|-----|----------|----|
| DL | 05/11/30 | 12 |
| SAD | 25/11/05 | 12 |

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



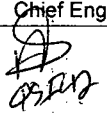
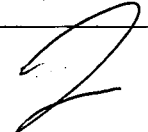
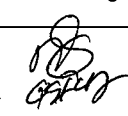
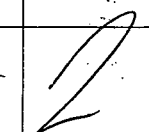
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

| | | |
|-----|---------|----|
| SAD | 3/12/05 | 12 |
|-----|---------|----|

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/12/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|---|--|----------------|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 05-11-28 | 2 | I.P.P. typo for part cut length. Parts are 1" too long. |  | Shear and debur parts too long & dims. | DU |  05-11-30 |  |  05-11-28 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 24956D

Part Number: D32203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



05-12-05

12

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 97

05/12/06

12

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

See 05/12/07 (12)

05/12/07 (12)

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries